

Work Order ID 127260

Tuesday, December 16, 2014 10:41:53 AM

127260

Page 1

Item ID: D2803-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 12/16/2014 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/16/2014 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 14-12-16 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2803	Rev B ✓								

100 Small Fab 0.00
100
 Small Fab Memo 0.00
 Small Fab Press D2805-2 and D2809 into arm as per Dwg D2803

4x 14/12/16 DAS 36 9-89

110 QC5- Inspect part completeness to step on W/O 0.00
110
 QC Memo 0.00
 Quality Control

④ 38 9-89 DEC 16 2014

120 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00
120
 Powdercoat Memo 0.00
 Powder Coating
 START TIME: 10:55 OVEN TEMPERATURE:
 FINISH TIME: 11:25

N. 14-12-17. DAS 34 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____ _____
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Work Order ID 127260

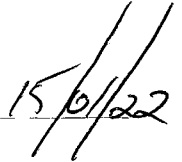
Tuesday, December 16, 2014 10:41:53 AM

127260

Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number DAS 38 9-89	Insp. Stamp
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							DEC 18 2014
150 *150* Small Fab Small Fab	Small Fab Memo Assemble as per Dwg D2803.	0.00 0.00							 DAS 36 9-89
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							DAS 38 9-89 JAN 23 2015

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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 3

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>ST473</u>	0.00				4x		DAS 26 9-89	JAN 2 R 2015
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

15/1/28 JF

15/1/28

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FAULT CATEGORY

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Picklist Print

Tuesday, December 16, 2014 10:41:59 AM

Page 1

Work Order ID: 127260

127260

Parent Item: D2803-042

D2803-042

Parent Item Name: Bracket Assembly

Start Date: 12/16/2014

Required Date: 12/16/2014

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2803-2		Manufactured	No			100	Each	0.0000	1	4			
D2803-2						B127083		(42)	**			14/12/16	DAS 36 9-89
Bracket													
D2805-2		Manufactured	No			100	Each	19.0000	1	4			
D2805-2									**			14/12/16	DAS 36 9-89
Stop													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				19					
				119687				7					
				125446				12		4			
NAS1515H3		Purchased	No			100	Each	195.0000	4	16			
NAS1515H3									**			14/12/18	DAS 36 9-89
Washer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				10					
				123301				10					
				GA				136					
				m129521				136		16			
				ST266				49					
				m128635				49					
AN3C16A		Purchased	No			150	Each	50.0000	2	8			
AN3C16A									**			14/12/18	DAS 36 9-89
BOLT													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST338a				50					
				m130466				50		8			

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FAULT CATEGORY

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Picklist Print

Tuesday, December 16, 2014 10:41:59 AM

Page 2

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Parent Item: D2803-042

Parent Item Name: Bracket Assembly

127260

D2803-042

Start Date: 12/16/2014

Required Date: 12/16/2014

Start Qty: 4.00

Required Qty: 4.00

D2809

Manufactured No

150 Each

14.0000 1 4

**

D2809

Washer

DAS

36

9-89

15/01/22

B127638

(1x)

3

Location

Loc Qty

Loc Code

GA

3

122436

3

ST011

11

34035

11

MS21043-3

Purchased No

150 Each

522.0000 2 8

**

MS21043-3

Nut

DAS

36

9-89

14/12/18

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

339

m130673

339

GA

60

m130186

60

ST304

43

m130673

43

8